

Date:
User:Thursday, 8/23/2007 11:53:34 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADAPTER
Job Number	: 34247		
Estimate Number	: 12674		
P.O. Number	: <i>N/A</i>	Part Number	: D35733
This Issue	: 8/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3573 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 33969	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/3/2007
Checked & Approved By	: <i>[Signature]</i> 07/08/23	Qty:	<i>40</i> Um: Each
Comment	: Est Rev: A New Issue 07-01-29 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X02500 6061-T6 Bar .50" x 2.5"



Comment: Qty.: 0.3066 f(s)/Unit Total : 2.4528 f(s)

6061-T6 Bar .50" x 2.5"

Batch: *M104366**J.L 07/12/03*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.500" long

J.L 07/12/03

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA673 and Dwg D3573

mk / J.L 07/12/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/12/04

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

FL 07/12/04

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1





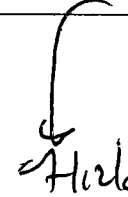
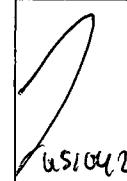
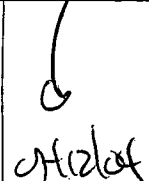
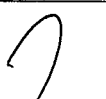
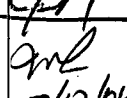

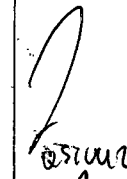
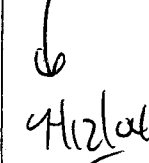

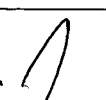
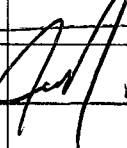
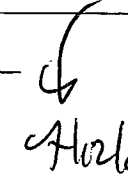
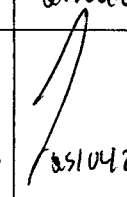
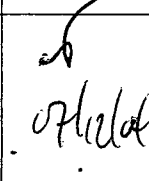
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
				Action Description Chief Eng	Sign & Date			
07/12/03	3	1 part is too thin dimension .390 $\pm .010$ is .383 E.C. Program error	 051042	Scrap and Destroy and Re-prog	 07/12/04	 Hirley	 051042	 Hirley
07/12/04	3	1 part is the counter- bore is to the small dimension .500 $\pm .006$ is .495 and dim. is	 051042	Scrap and Destroy and Re-prog 2 x B.M104366	 07/12/04	 Hirley	 051042	 Hirley
	↓ 2	E.C. no cutter compensation after tool has been re-sharpened.	 051042	ADD cutter comp		 Hirley	 051042	 Hirley

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 34247

Part Number: D35733

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M 10 5642



(40x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 07/12/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(No)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JK 07-12-05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Sylvie



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 244

7/12/06 sd

(40x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40x)

Comment: FINAL INSPECTION/W/O RELEASE

DD 07/12/06

Job Completion



U 08.12.06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

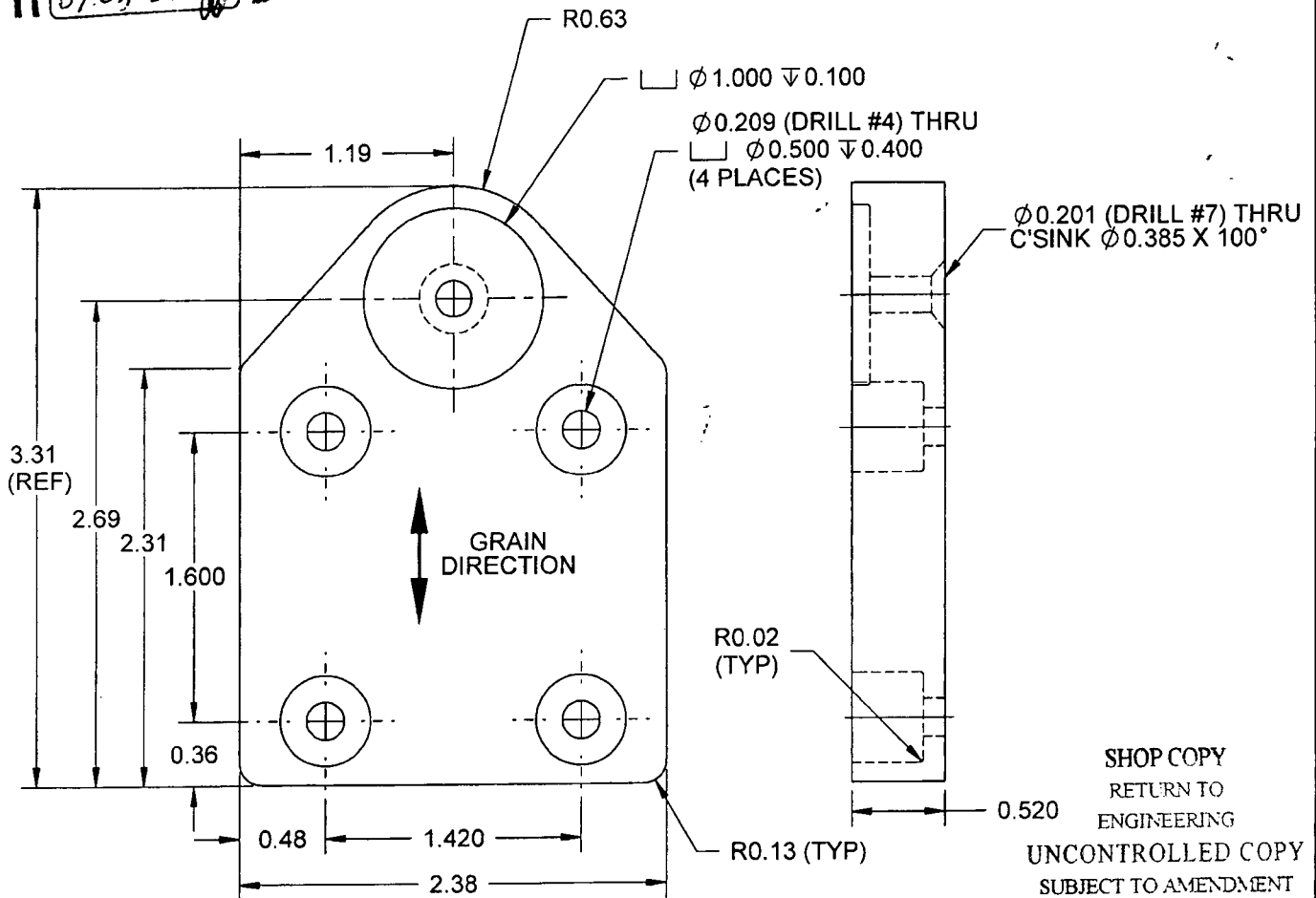
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

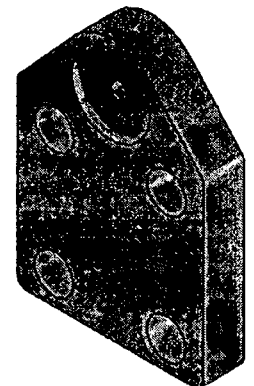
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER**

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WORK ORDER
NO. 34247

NOTES:

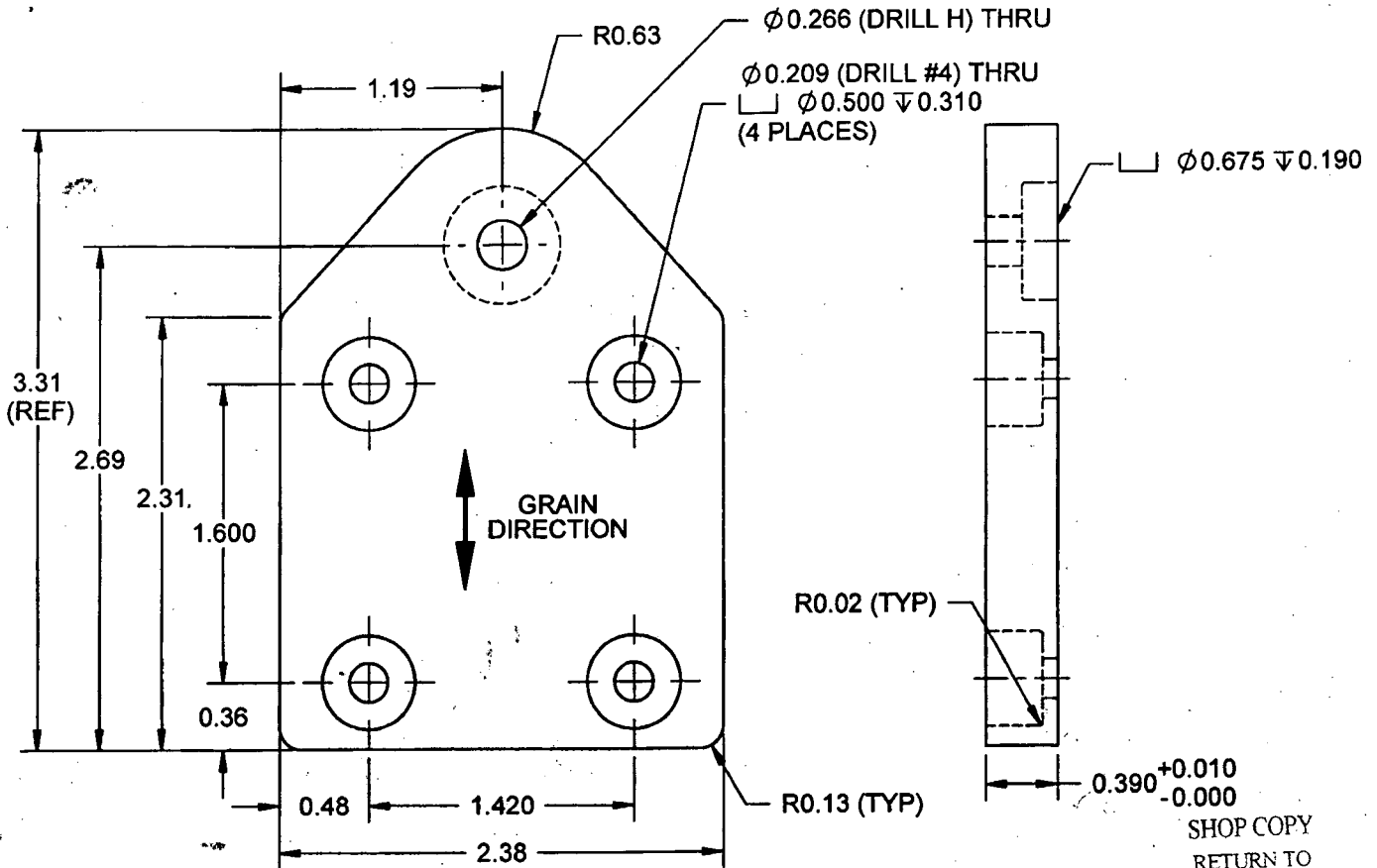
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART

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DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
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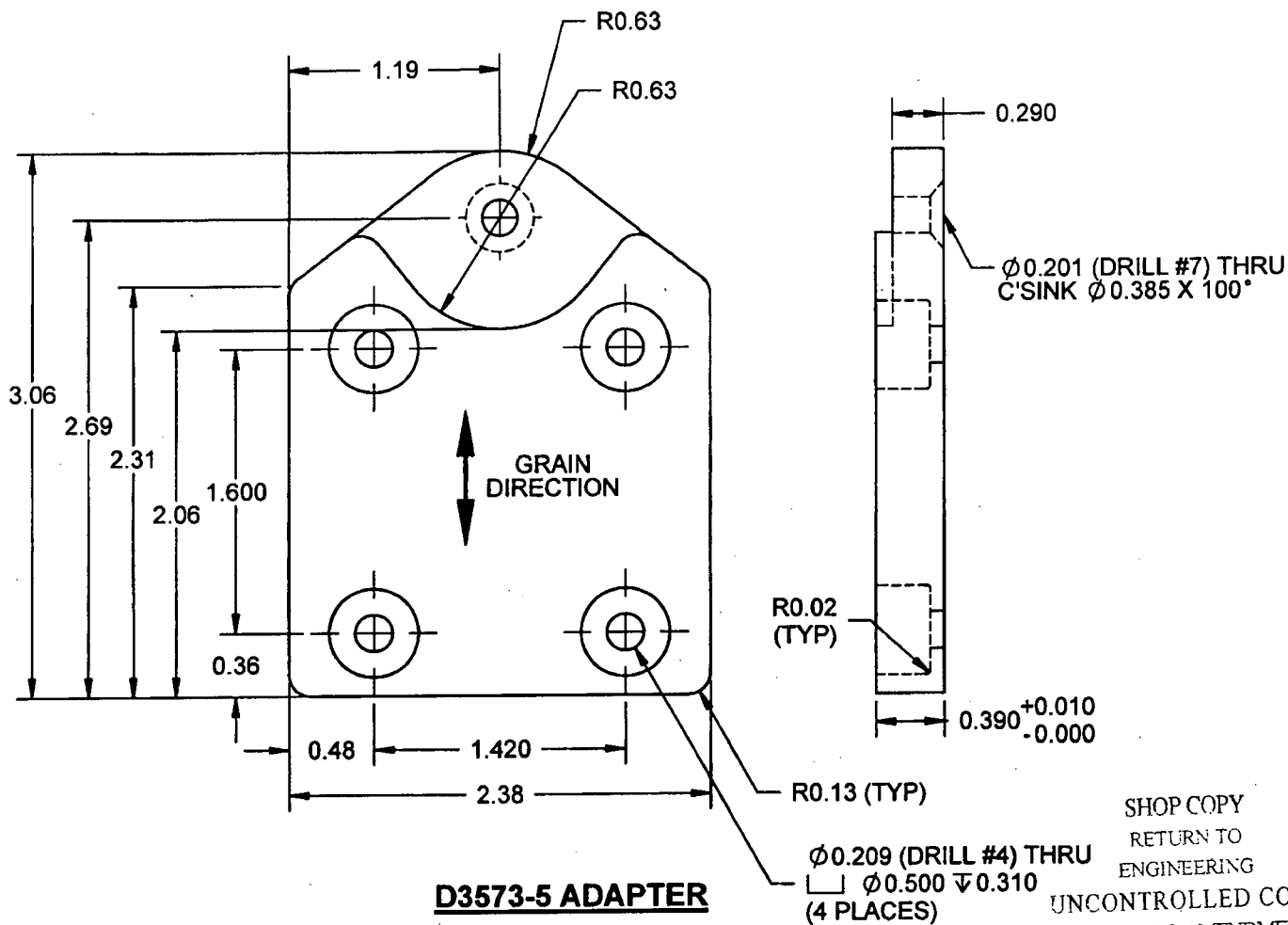
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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02



D3573-5 ADAPTER

Ø0.209 (DRILL #4) THRU
□ Ø0.500 ±0.310
(4 PLACES)

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NOTES:

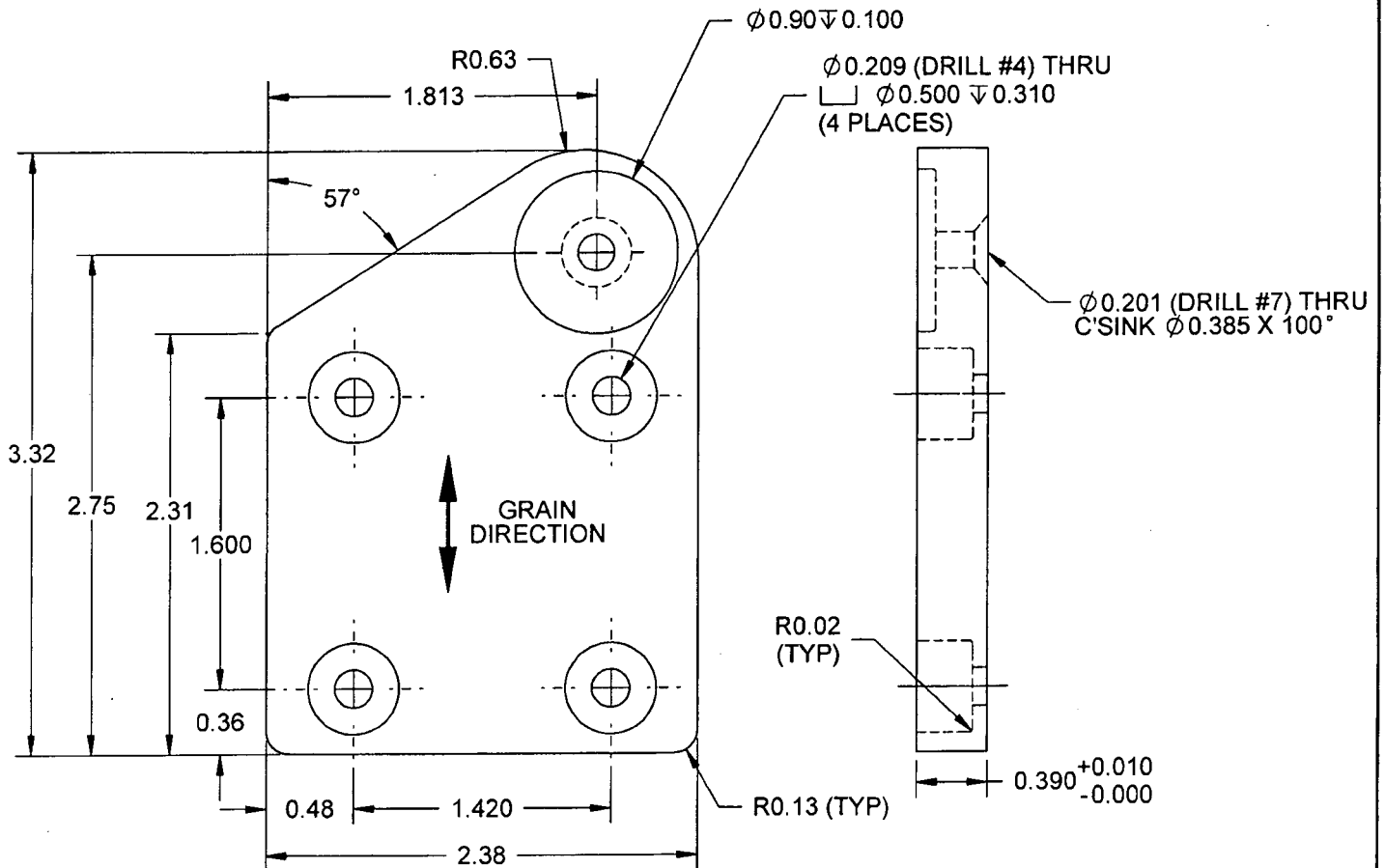
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PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
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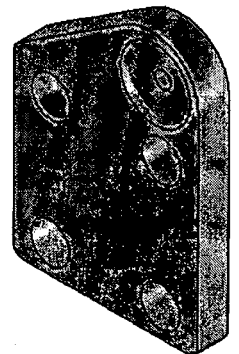
DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02

D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

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WITHOUT NOTICE
WORK ORDER
NO. 34247



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
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